

Date: Thursday, 10/04/2008 10:37:04 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: CABIN FLOOR PROTECTOR		
Job Number	: 38517			Part Number	: D35745		
Estimate Number	: 12969			Drawing Number	: D3574 REV.A		
P.O. Number	:			Project Number	: N/A		
This Issue	: 10/04/2008 S.O. No. :			Drawing Revision	: A		
Prsht Rev.	: NC			Material	:		
First Issue	: 10/04/2008 Type : SMALL /MED FAB			Due Date	: 18/04/2008 Qty: 2 Um: Each		
Previous Run	: 35947						
Written By	:						
Checked & Approved By	: <u>JL</u> 08.4.10						
Comment	: Est Rev:A New Issue 07.07.23 EC verified by:JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	F60029 mLexan125	lexan grey
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10/04/10



Comment: Qty.: 32.0000 sf(s)/Unit Total : 64.0000 sf(s)

F60029 lexan sheet

Batch: 103106 1B 8-4-11

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3574

Dwg Rev: A

Prog Rev: A

(2)

2-Deburr if necessary

1B 8-4-11

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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1B 8-4-11

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

10/04/11 (2)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.

SAN 08/04/13 (2)

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/04/2008 10:37:05 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABIN FLOOR PROTECTOR

Job Number: 38517

Part Number: D35745

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5



INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/04/14 (X2)

7.0 PACKAGING 1



PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock
Location: 000 38516

AS of 04/14 (X2)

8.0 QC21



FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/14 (X2)

Job Completion



MF 08-04-16

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

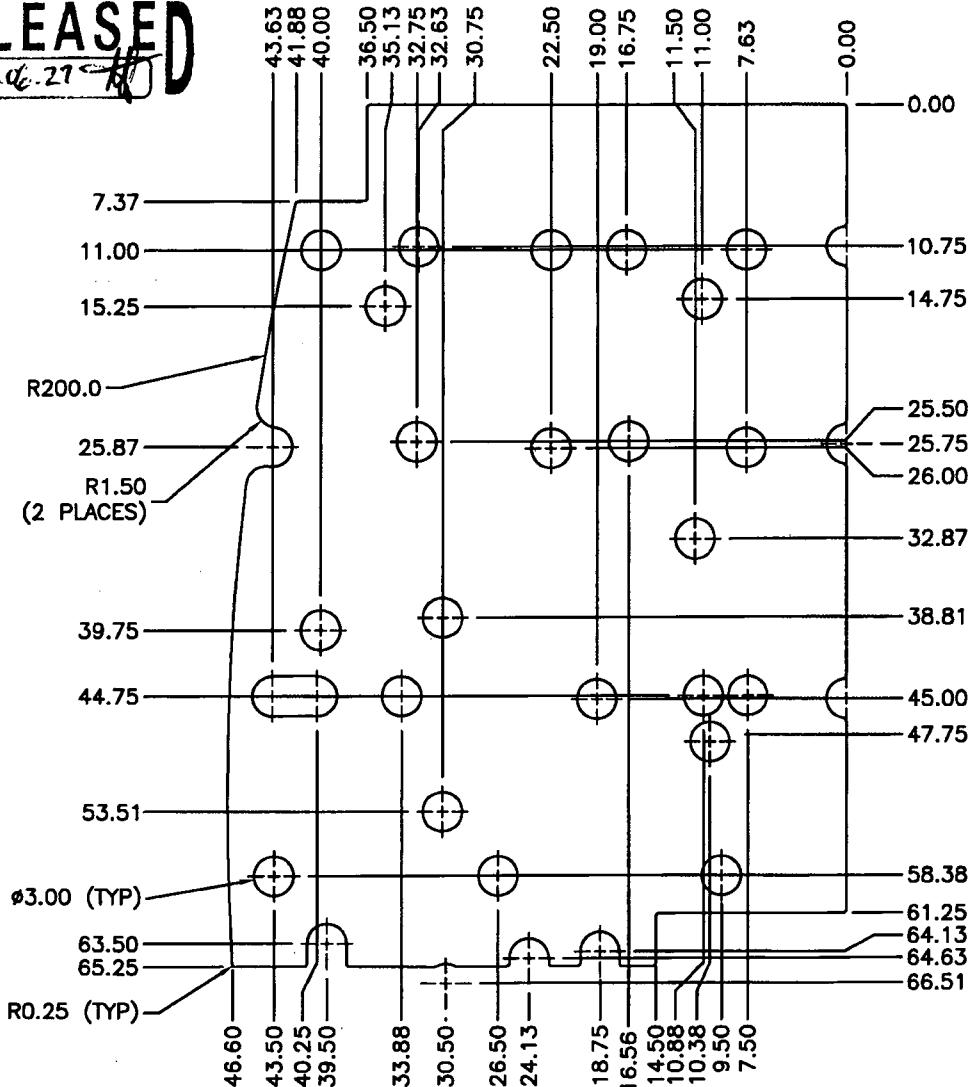
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>CE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>HT</i>	DRAWING NO. D3574	REV. A SHEET 1 OF 5
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14
A	07.06.08	NEW ISSUE	

RELEASED
07.06.27 HT

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WORK ORDER
NO. 38517

D3574-1 CABIN FLOOR PROTECTOR (SHOWN). D3574-2 (OPPOSITE)**NOTES:**

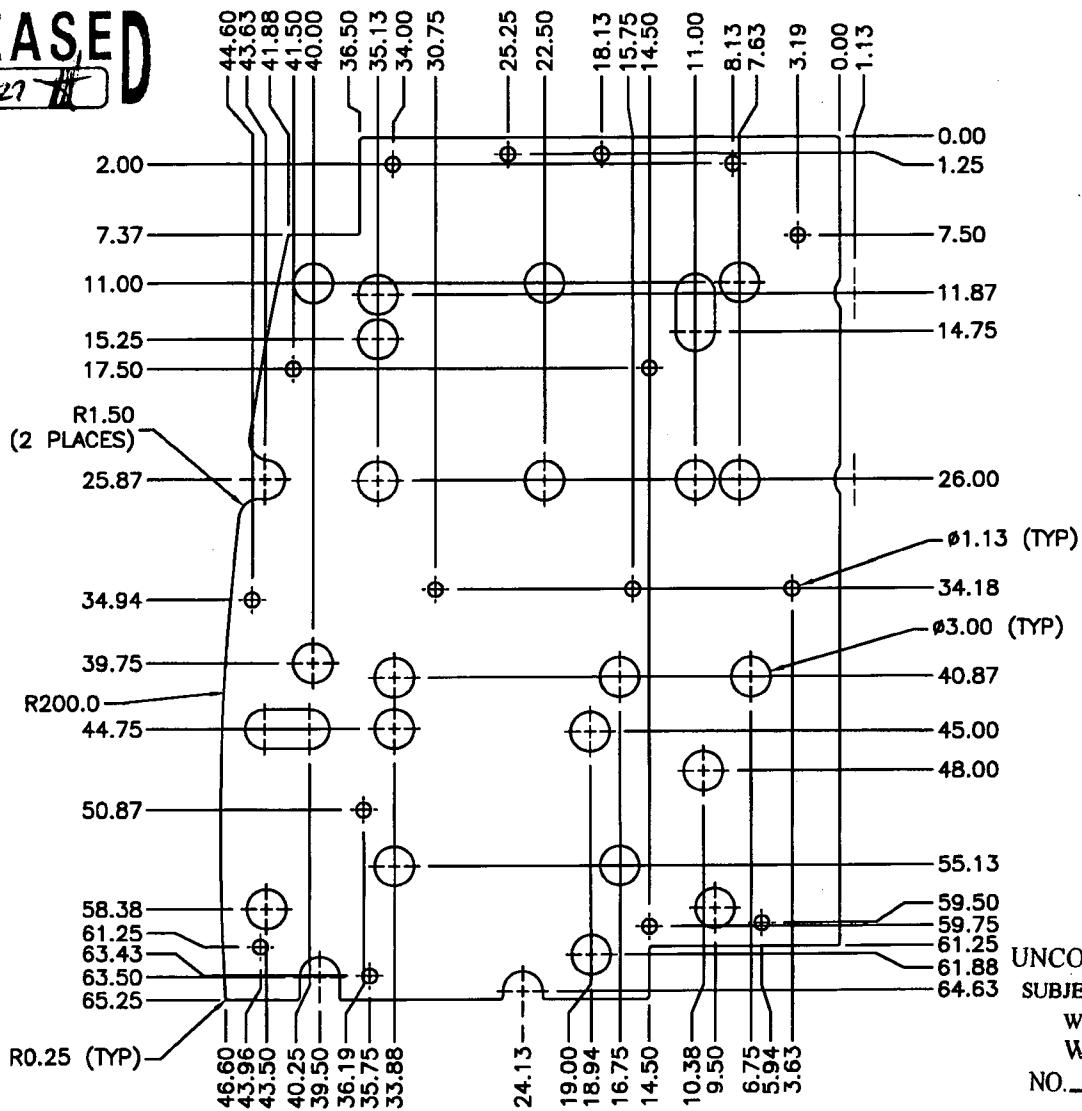
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-1/-2" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8961

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DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14

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07.06.08

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WORK ORDERNO. 38517**D3574-3 CABIN FLOOR PROTECTOR****NOTES:**

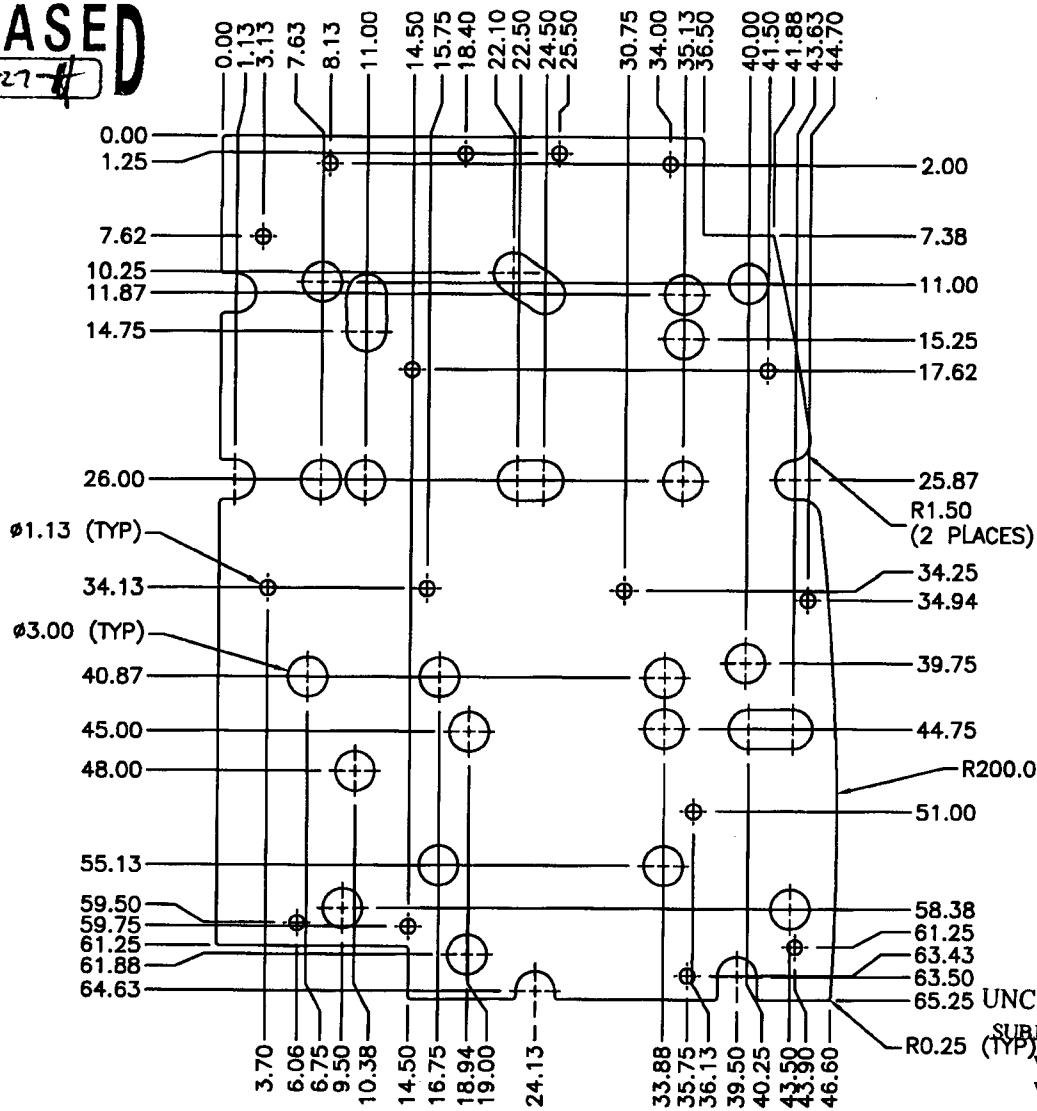
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-3" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
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DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14

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07.06.27

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NO. 38517

D3574-4 CABIN FLOOR PROTECTOR**NOTES:**

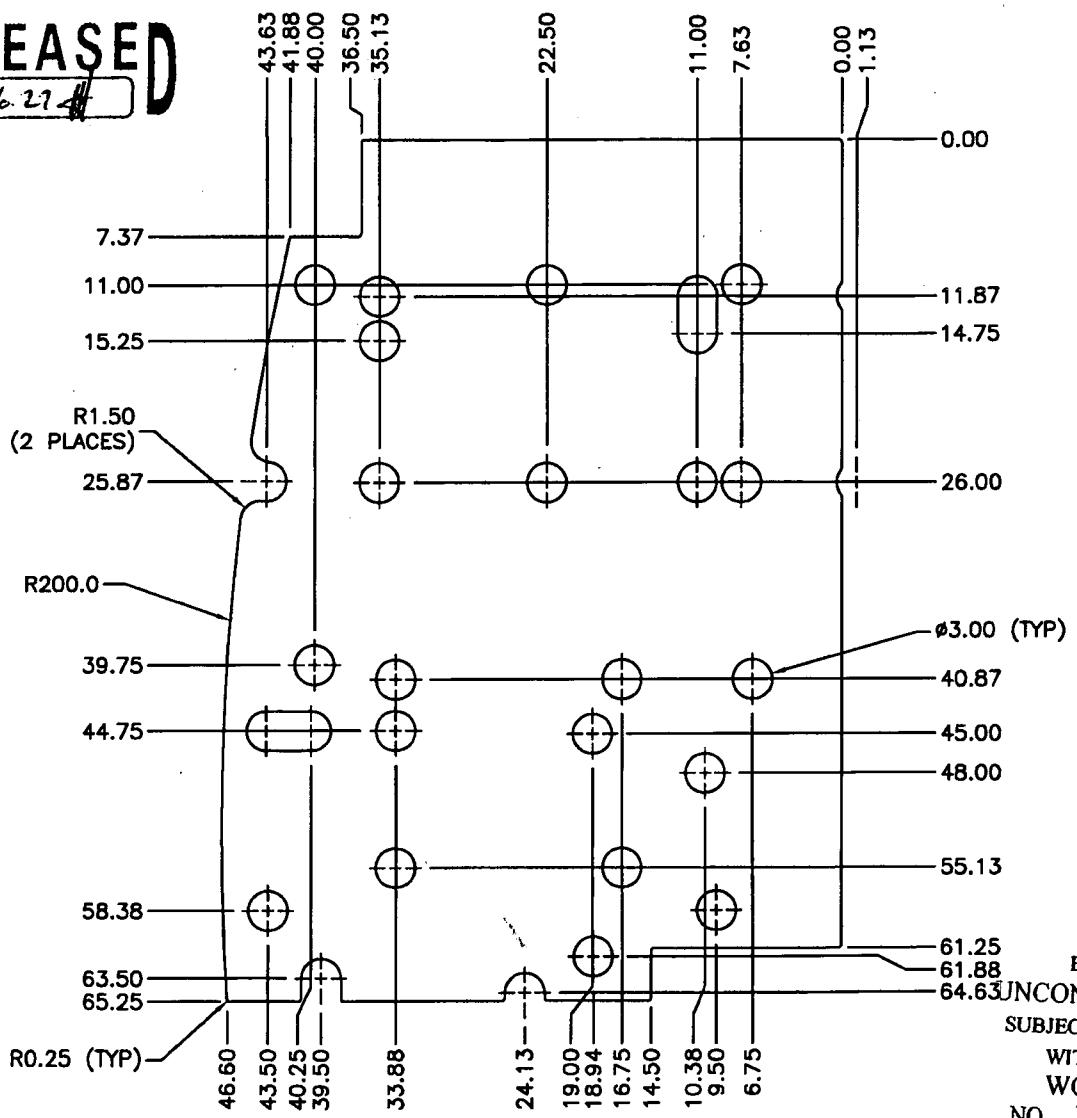
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-4" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8963

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DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14

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NO. 38507

D3574-5 CABIN FLOOR PROTECTOR**NOTES:**

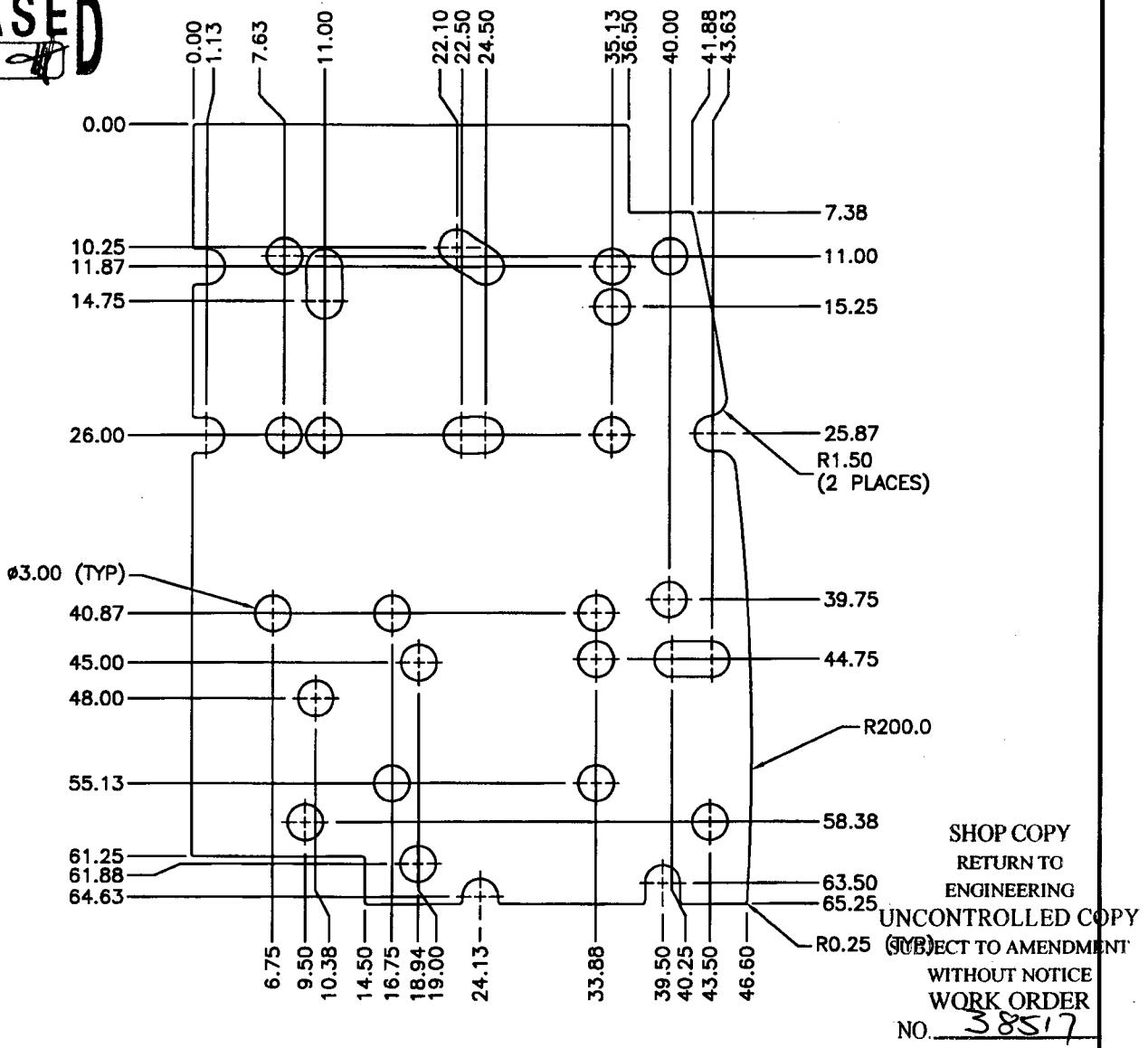
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-5" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8964

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DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14

RELEASED
07.06.08**D3574-6 CABIN FLOOR PROTECTOR**NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-6" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
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DART AEROSPACE LTD	Work Order:	38517
Description: CABIN FLOOR PROTECTOR	Part Number:	D3574-5
Inspection Dwg: D3574-5 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article | Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 3.00	+ .012 - .001	3.001	*			
7.37	+/- .030	7.37	*			
11.00	+/- .030	11.00	*			
15.25	+/- .030	15.25	*			
39.75	+/- .030	39.75	*			
44.75	+/- .030	44.75	*			
58.38	+/- .030	58.38	*			
63.50	+/- .030	63.50	*			
65.25	+/- .030	65.25	*			
11.87	+/- .030	11.87	*			
14.75	+/- .030	14.75	*			
26.00	+/- .030	26.00	*			
40.87	+/- .030	40.87	*			
45.00	+/- .030	45.00	*			
48.00	+/- .030	48.00	*			
55.13	+/- .030	55.13	*			
61.25	+/- .030	61.25	*			
61.88	+/- .030	61.88	*			

Measured by: HB	Audited by: S	Prototype Approval: d
Date: 8-4-11	Date: 08/01/14	Date: 07

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

10

DART AEROSPACE LTD	Work Order:	38517
Description: CABIN FLOOR PROTECTOR	Part Number:	D3574-5
Inspection Dwg: D3574-5 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
7.63	+/- .030	7.63	*			
11.00	+/- .030	11.00	*			
22.50	+/- .030	22.50	*			
35.13	+/- .030	35.13	*			
36.50	+/- .030	36.50	*			
40.00	+/- .030	40.00	*			
41.88	+/- .030	41.88	*			
6.75	+/- .030	6.75	*			
9.50	+/- .030	9.50	*			
10.38	+/- .030	10.38	*			
14.50	+/- .030	14.50	*			
16.75	+/- .030	16.75	*			
18.94	+/- .030	18.94	*			
19.00	+/- .030	19.00	*			
24.13	+/- .030	24.13	*			
33.88	+/- .030	33.88	*			
39.50	+/- .030	39.50	*			
40.25	+/- .030	40.25	*			
43.50	+/- .030	43.50	*			
46.66	+/- .030	46.66	*			

Measured by-

142

Audited by:

Prototype Approval:

a

Date:

3 July 11

Date: 1963-01-14

Date: _____

2

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

10